

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 142610

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142610

Page 2

Item ID: D4635-144 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Ceiling Replacement Panel Assembly, RH
Start Date: 3/14/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/31/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							DAS 07 9-89
110						x1			
Small Fab	Memo	0.02							
Small Fab	Assemble as per Dwg D4635-144 Bond foam core to inside of panel 3M Scotch Weld 1300 Batch: <u>132830</u>								16/03/29
	1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe								
	2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8)								
	Batch # <u>183719</u>								
	Expiry Date <u>11/16</u>								
	3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9)								
	Batch: <u>129423</u>								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							DAS 9 9-89
Quality Control						① 1603-30			

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142610

Page 3

Item ID: D4635-144

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Ceiling Replacement Panel Assembly, RH

Start Date: 3/14/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 3/31/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							DAS 07 9-89
130	W/O # 142600								
Packaging	Memo	0.00				x1			16/03/30.
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							MCS MAR 30 2016
Quality Control									

MCS MAR 30 2016

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
						QC / QA Coordinator Approval			

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER :			
Misidentified ☐	☐	Past Due	☐				

Picklist Print

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Page 1

Work Order ID: 142610

142610

Parent Item: D4635-144

D4635-144

Parent Item Name: Aft Ceiling Replacement Panel Assembly, RH

Start Date: 3/14/2016

Required Date: 3/31/2016

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev. A 12/08/09 New Issue DL

IPP Rev B

12/11/08 Doc Release DL

IPP Rev. C Dwg.

Update 13/07/09 DL verf:DD

IPP Rev D Dwg Update

13/12/09 DL

Ipp Rev. E Dwg Update 14/01/09 DL

IPP Rev. F

Dwg. Update 15/01/27 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4635-4		Manufactured	No			100	Each	0.0000	1	1			DAS 07 9-89
D4635-4					#142611				**	1			14/03/28
Aft Ceiling Panel, RH													
D4669-1		Manufactured	No			100	Each	45.0000	1	1			DAS 07 9-89
D4669-1									**				14/03/28
Bracket													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MF004		45							
				124100		5				1			
				125017		40							
D4695-4		Manufactured	No			100	Each	6.0000	1	1			DAS 07 9-89
D4695-4									**				14/03/28
Channel													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MF		2							
				125016		2				1			
				ST454		4							
				126498		4							

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OTHER : ☐					

Picklist Print

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Page 2

Work Order ID: 142610

142610

Parent Item: D4635-144

D4635-144

Parent Item Name: Aft Ceiling Replacement Panel Assembly, RH

Start Date: 3/14/2016

Required Date: 3/31/2016

Start Qty: 1.00

Required Qty: 1.00

D4732-11

Manufactured No

100

Each

16.0000

1

1

D4732-11

Label

DAS
07
9-89

Location

Loc Qty

Loc Code

MF

16

120066

4

123205

12

16/03/28

D4732-39

Manufactured No

100

Each

15.0000

1

1

D4732-39

Label

DAS
07
9-89

Location

Loc Qty

Loc Code

MF005

15

120080

3

123219

12

16/03/28

D4732-41

Manufactured No

100

Each

15.0000

1

1

D4732-41

Label

DAS
07
9-89

Location

Loc Qty

Loc Code

MF005

15

120081

3

123220

12

16/03/28

D5022-5

Manufactured No

100

Each

10.0000

1

1

D5022-5

Foam, Side Panel, Aft

DAS
07
9-89

Location

Loc Qty

Loc Code

CA2

10

123920

6

126186

4

16/03/28

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Shop Packet Print

Page 2

DQA: _____ Date: _____



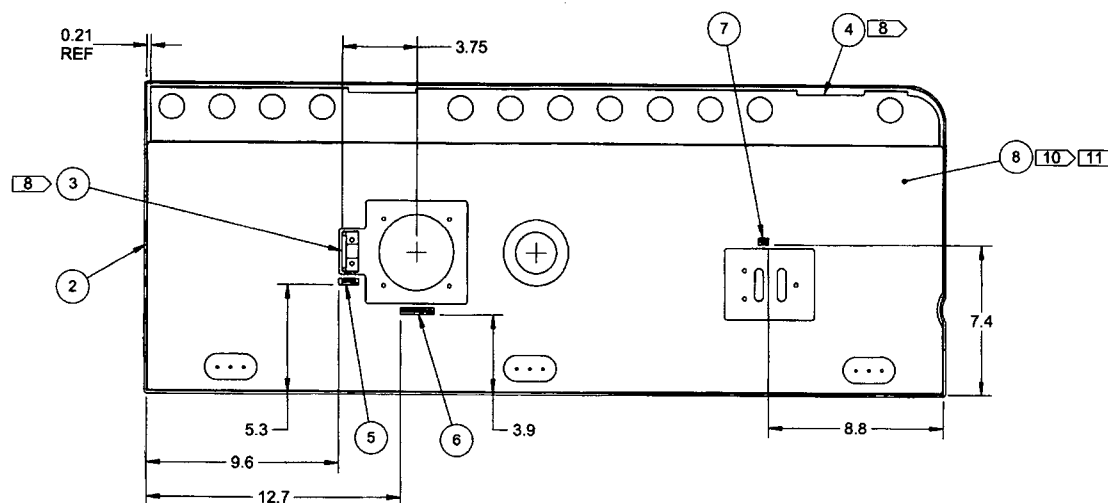
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OTHER : ☐					

ITEM	QTY	P/N	DESCRIPTION
1	X	D4635-144	RH, AFT CEILING REPLACEMENT PANEL ASSY
2	1	D4635-4	RH, AFT CEILING PANEL
3	1	D4669-1	BRACKET
4	1	D4695-4	CHANNEL
5	1	D4732-11	LABEL
6	1	D4732-39	LABEL
7	1	D4732-41	LABEL
8	1	D5022-5	FOAM, SIDE PANEL, AFT, RH



D4635-144 RH, AFT CEILING REPLACEMENT PANEL ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) APPLY A BEAD (0.20 TO 0.30 WIDE) OF DEVCON PLASTIC WELDER II (0.25 INSIDE OF BOTH EDGES OF PART) TO BOND D4669-1, D4695-4. WAIT FOR 2 TO 4 HOURS FOR FUNCTIONAL CURE
- 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) APPLY AN EVEN COAT OF 3M SCOTCH WELD 1300L CONTACT ADHESIVE TO BOND D5022-5 FOAM CORE TO INSIDE OF PANEL
- 11) CENTER D5022-5 FOAM ON D4635-4

RELEASED

2015 JAN 26

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. F
MFG. APPR.	DL	D4635	SHEET 12 OF 18
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	OUTBOARD CEILING PANELS	NTS
DATE	14.11.28	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐							
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